










Work Order ID 56592

Tuesday, March 02, 2010 8:27:23 AM

Page 1

Item ID:	D3136-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Window Assembly				Stop	
Start Date:	3/2/2010	Start Qty:	4.00			
Required Date:	3/16/2010	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	<i>MA</i>	Date:	<i>10-3-01</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	Rev E								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	<i>E</i>								
	<i>E</i>								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

HB10-3-8

(4)

HB10-3-8

8/10/09

x4

Pho

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-043 PAR #: _____ Fault Category: Small Parts/Water Jet NCR: (Yes) No DQA: _____ Date: 10/04/08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 9/2 Date: 10/04/12

NCR: <u>56592</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/06</u>	<u>120</u>	<u>Found Denum inspection that Qty +1 window 0.100" step out in on corner. R.C. Part moved Denum water Jet in R.C. Process</u>	<u>[Signature]</u>	<u>-Scrap + Destroy Qty +1 AND Replace M 11384</u>	<u>10-3-9</u>	<u>S 10/09/07</u>	<u>[Signature]</u>	<u>S 10/03/06</u>
			<u>[Signature]</u>					

NOTE: Date & initial all entries

Work Order ID 56592

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Item ID: D3136-043

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Revision ID:

Item Name: Window Assembly

Start Date: 3/2/2010 Start Qty: 4.00

Required Date: 3/16/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

1-Thermoform as per Dwg D3136 and Folio FTA002 Dwg
Rev. E Folio Rev. C 2- Engrave Part # and
Batch # , and affix labels (D3136-3)

0.00

0.00

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

150



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Dh. 10/03/11 (x4)

Dh. 10/03/11 (x4)

Dh. 10-03-11 (4)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start

Revision ID:

Stop

Item Name: Window Assembly

Start Date: 3/2/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 3/16/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

DL 10/03/11 (X4)

170

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 10/03/11

(X4)

180

0.00



Identify as per dwg & Stock Location: 216

Packaging

Memo

0.00

Packaging

P 10/03/11 (4)

W/O:		WORK ORDER CHANGES					
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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/01 *[Signature]*PL 10-3-29
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Page 1

Work Order ID: 56592



Parent Item: D3136-043



Parent Item Name: Window Assembly

Start Date: 3/2/2010

Required Date: 3/16/2010

Comments: IPP Rev:A 04.02.04 New issue KJ/DS
IPP Rev.B 07.05.29 Thermoform in-house DL
IPP rev C 07.09.28 Rev E dwg EC verified by:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3108-9		Manufactured	No			100	Each	740.0000	8.0000			
Decal												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

740

34554

252

46546

488

MACRLICS.125

Purchased

No

170

sf

288.3854

15.6000



1/8" Polycast II Sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

288.385401

110115

4

110633

17.2295

111711

67.7447

112888

0.782801

113204

20.61

113861

178.0184

x 8

DL 10/03/11

B10-3-8

(4)

113861

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